

Work Order ID 52286

Tuesday, September 22, 2009 1:35:27 PM



Page 1

Item ID:	D3514-3	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Box Top (Top Mounted)					
Start Date:	9/23/2009	Start Qty:	4.00			
Required Date:	10/6/2009	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>09/09/24</u>	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3514	Rev A

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3514 <input type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u>								
	<input type="checkbox"/> ***Ensure Grain Direction is corect***** <input type="checkbox"/> 2-Deburr if necessary								

IB 9-10-14

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

IB 9-10-14

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

2) Sorlooly

(48)

Work Order ID 52286

Tuesday, September 22, 2009 1:35:27 PM

Page 3

Item ID: D3514-3

Accept

Revision ID: A

Item Name: Box Top (Top Mounted)

Start Date: 9/23/2009 Start Qty: 4.00

Required Date: 10/6/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

2) 8 or 10/19

QC

Memo

0.00

Quality Control

(X4)

/

170

Chemical Conversion Coat per QSI005 4.1

0.00

BR 09-10-20

HandFinish

Memo

0.00

Hand Finishing

(2)

180

QC3- Inspect Part Finish

0.00

JLS 09/10/20

QC

Memo

0.00

Quality Control

(X4)

/

Work Order ID 52286

Tuesday, September 22, 2009 1:35:27 PM



Page 4

Item ID: D3514-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Box Top (Top Mounted)

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/6/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 179

0.00



Packaging

Memo

0.00

Packaging

9/10/09 (WSP)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/09 RFMF
09-10-21

Picklist Print

Tuesday, September 22, 2009 1:35:26 PM

Page 1

Work Order ID: 52286



Parent Item: D3514-3RevA



Parent Item Name: Box Top (Top Mounted)



Start Date: 9/23/2009

Required Date: 10/6/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	114.0568	1.9297			
												
6061-T6 .040 Sheet												

13 9-10-14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

114.0568

100742

3.3

102723

7.93

105842

12

106747

12.5

107461

13.1642

109396

22.28

111224

41.3826

19380

1.5

111 224

DART AEROSPACE LTD		Work Order: 52286
Description: Box Top (Top Mounted)		Part Number: D3514-3
Inspection Dwg: D3514 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

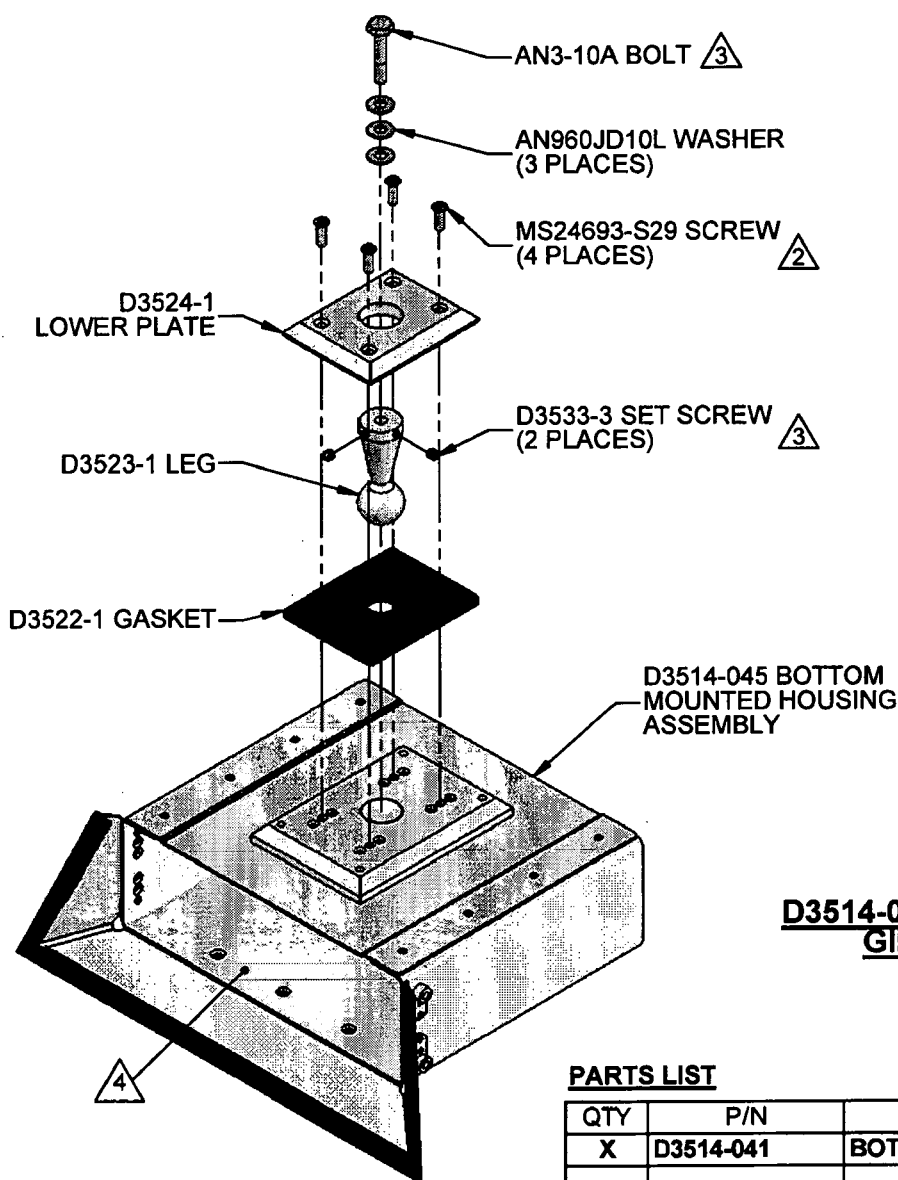
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	X			
Ø0.129	+0.005/-0.001	.134	X			
Ø0.144	+0.005/-0.001	.147	X			
12.00	+/-0.030	12.00	X			
5.500	+/-0.010	5.502	X			
5.000	+/-0.010	4.997	X			
3.650	+/-0.010	3.649	X			
3.500	+/-0.010	3.498	X			
2.000	+/-0.010	1.999	X			
1.850	+/-0.010	1.850	X			
0.500	+/-0.010	.498	X			
6.000	+/-0.010	6.000	X			
5.703	+/-0.010	5.706	X			
3.493	+/-0.010	3.494	X			
1.500	+/-0.010	1.500	X			
1.400	+/-0.010	1.401	X			
3.184	+/-0.010	BEND	X			
5.247	+/-0.010	BEND	X			

Measured by: UB	Audited by: S	Prototype Approval:	N/A
Date: 9-10-14	Date: 09/10/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	DA

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 1 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3
REV A	DATE 07.06.18	DESCRIPTION NEW ISSUE	

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07.08.03

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52286

**D3514-041 BOTTOM MOUNTED
GIMBAL ASSEMBLY****PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

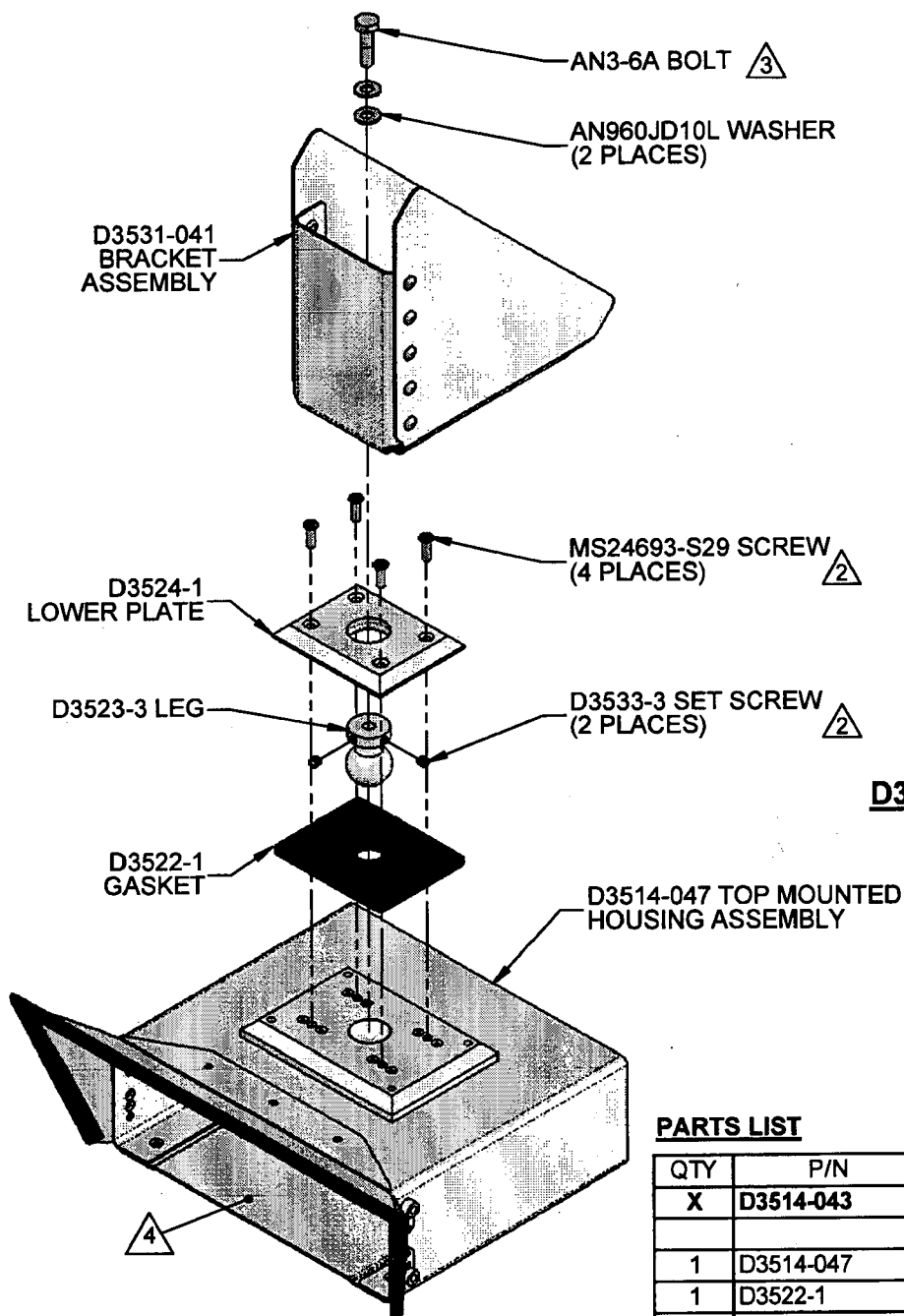
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3

RELEASED
07.08.03



D3514-043 TOP MOUNTED GIMBAL ASSEMBLY

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

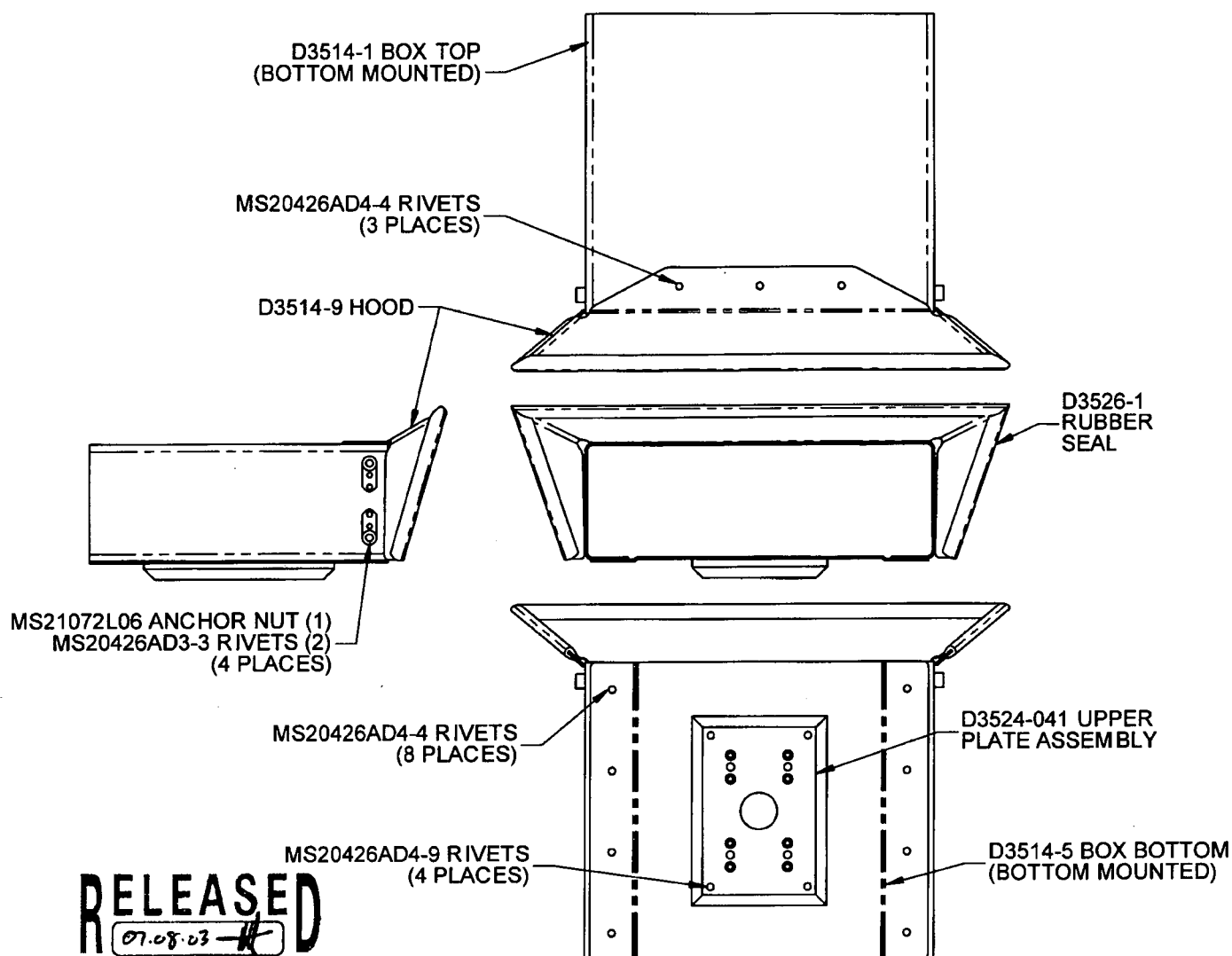
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3

**D3514-045 BOTTOM MOUNTED
HOUSING ASSEMBLY****NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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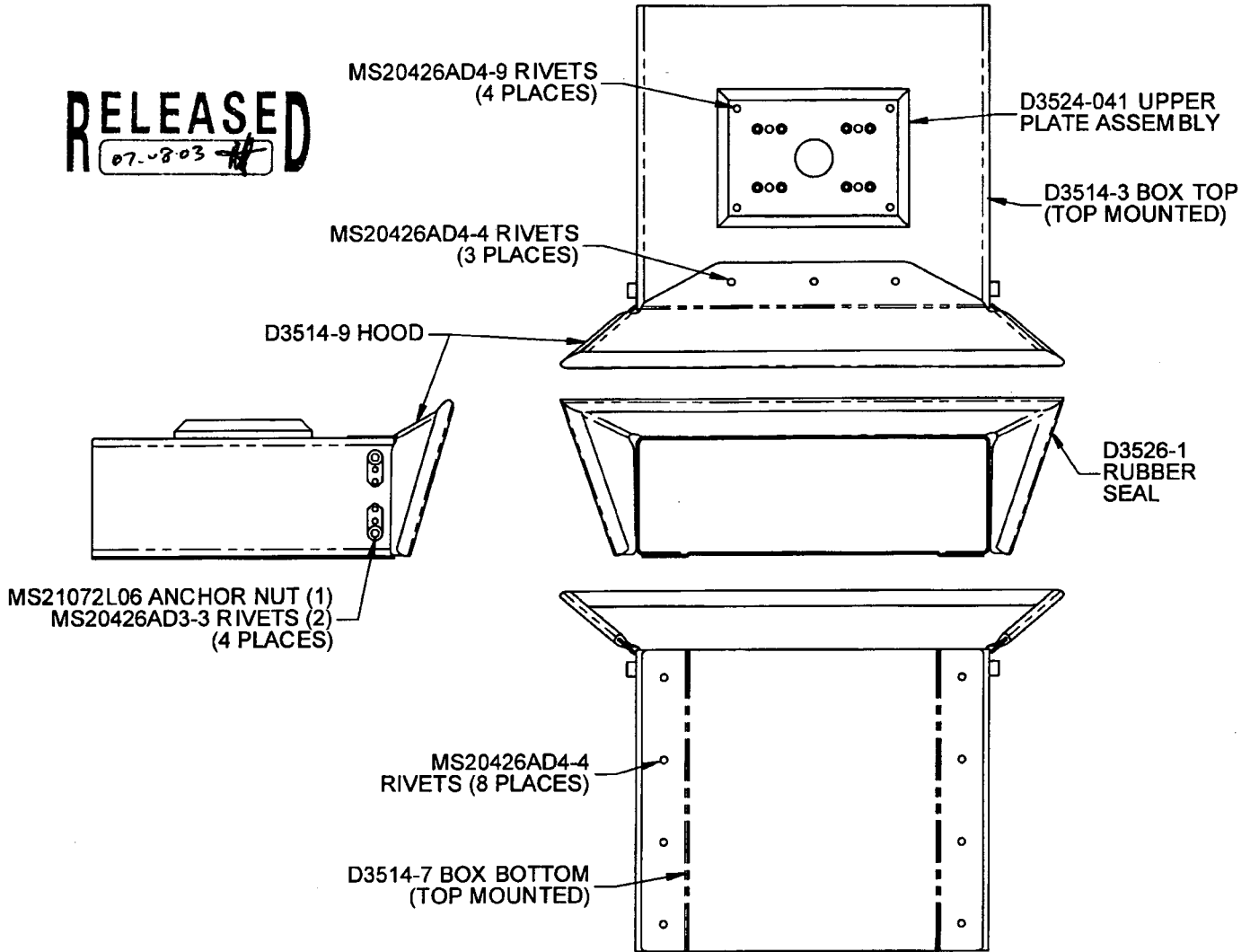
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3

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07-08-03 [Signature]



**D3514-047 TOP MOUNTED
HOUSING ASSEMBLY**

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

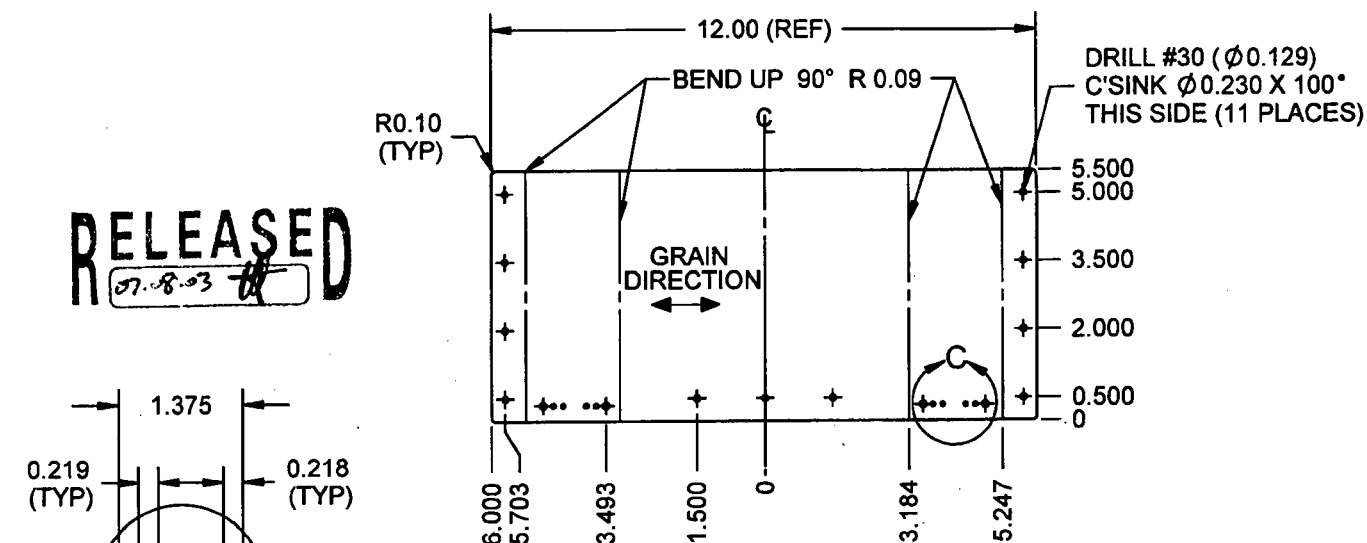
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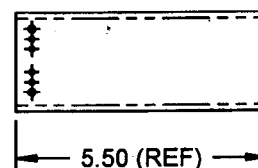
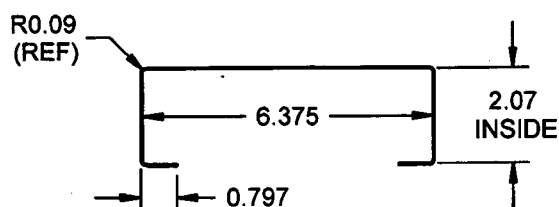
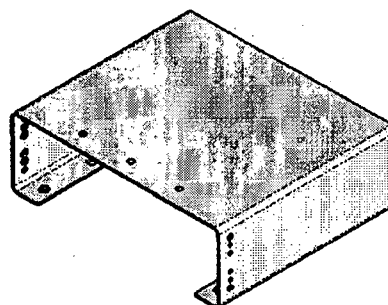
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING SCALE 1:4	

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D3514-1F
FLAT PATTERN



D3514-1 BOX TOP (BOTTOM MOUNTED)

NOTES:

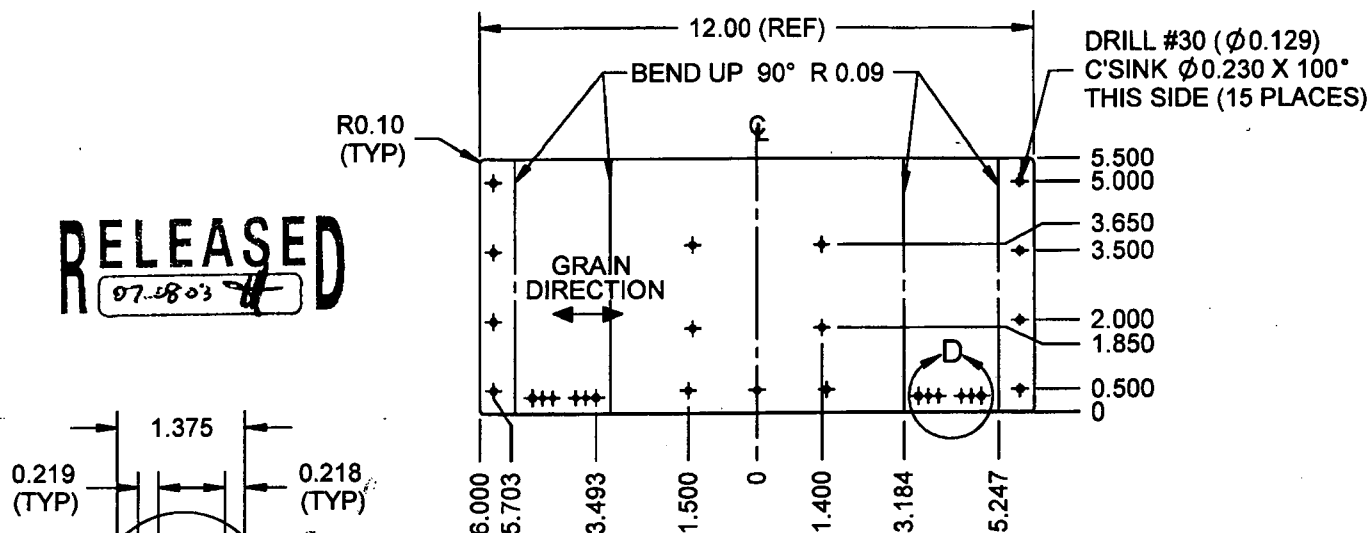
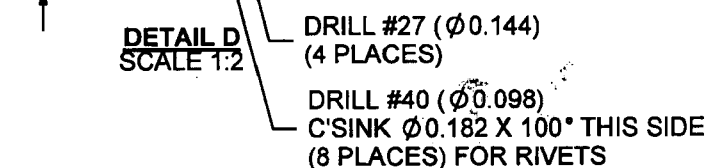
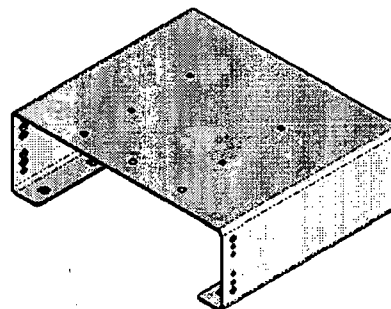
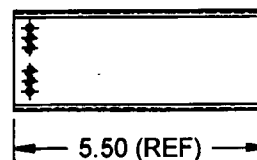
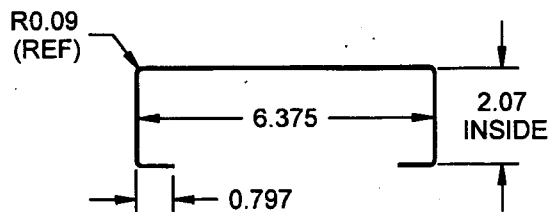
- NOTES:**
- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
 - 6) PART IS SYMMETRIC ABOUT ϕ
 - 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:4

RELEASED
97-2803**D3514-3F
FLAT PATTERN****DETAIL D
SCALE 1:2**DRILL #27 (Ø0.144)
(4 PLACES)DRILL #40 (Ø0.098)
C'SINK Ø0.182 X 100° THIS SIDE
(8 PLACES) FOR RIVETS**D3514-3 BOX TOP (TOP MOUNTED)****NOTES:**

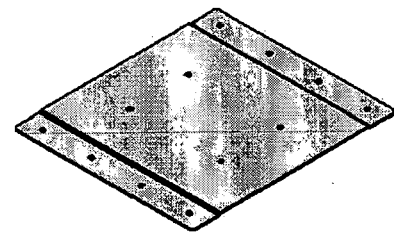
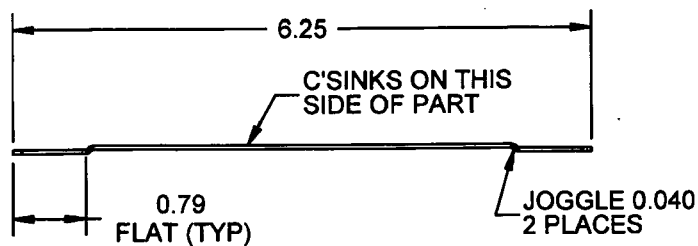
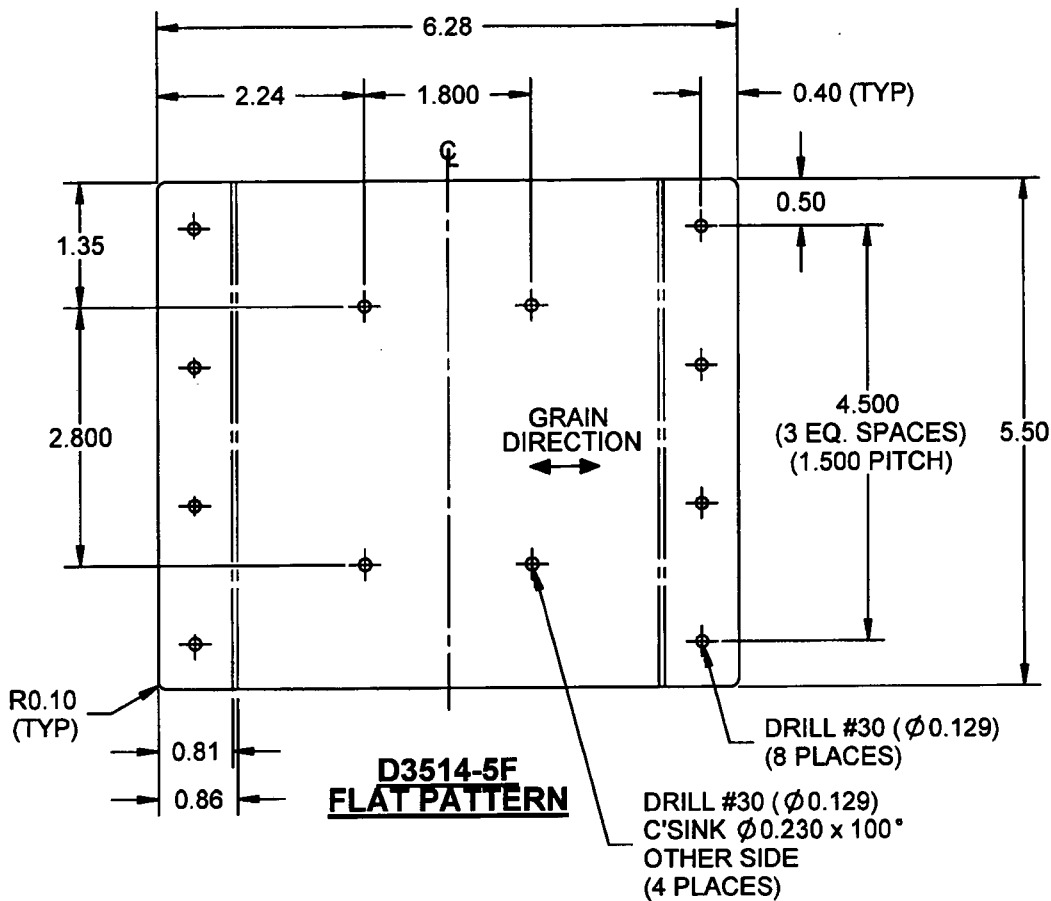
- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINK ABOVE JOGGLE

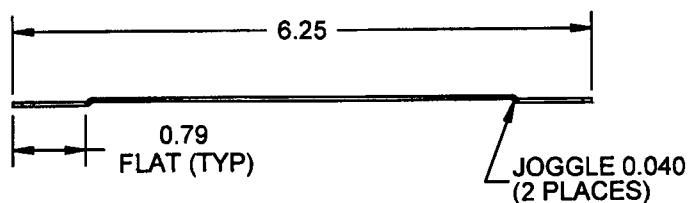
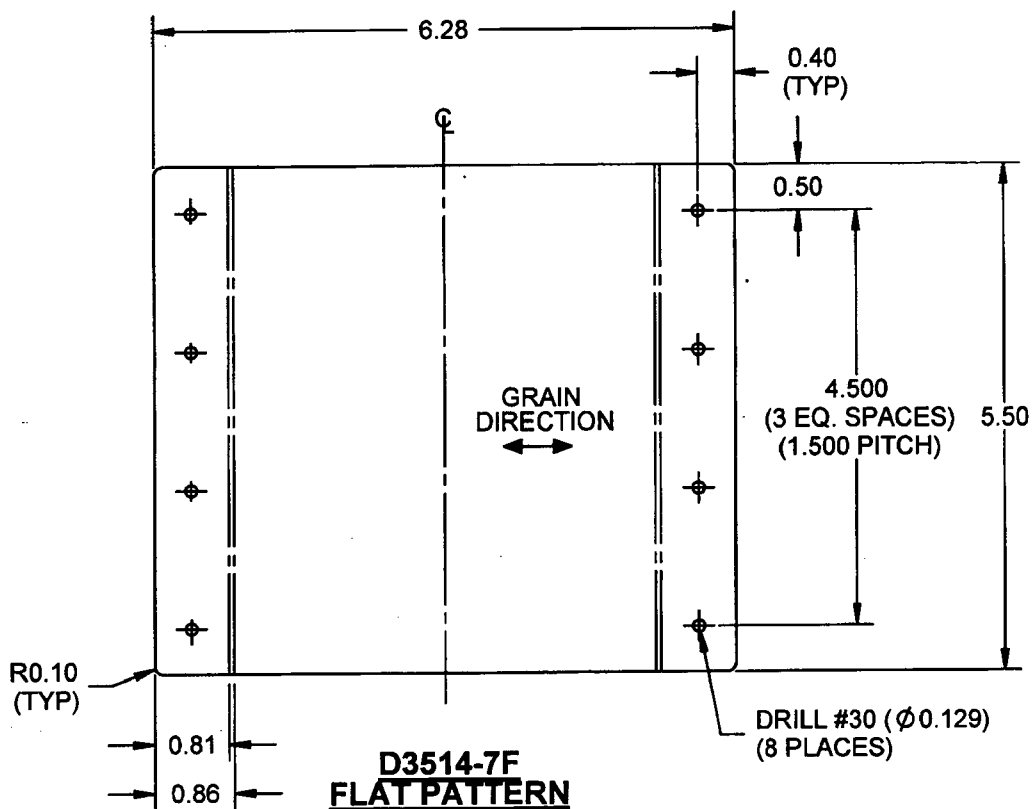
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2

**D3514-7 BOX BOTTOM (TOP MOUNTED)****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT \bar{C}

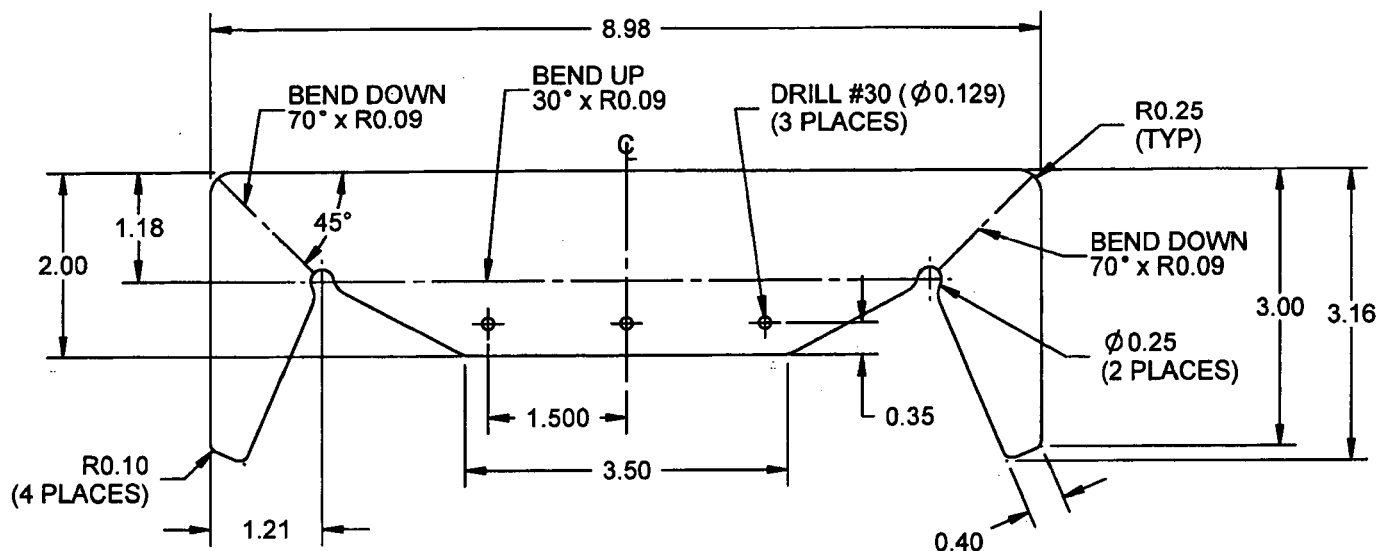
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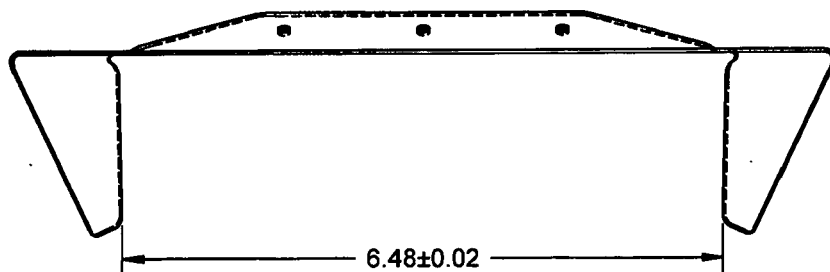
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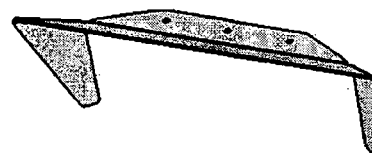
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



D3514-9F
FLAT PATTERN



FRONT VIEW



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D3514-9 HOOD

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

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